

Work Order ID 58688

Monday, May 17, 2010 8:25:50 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 5/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-5-17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

3AD 10-05-26

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" annd use jig for other line***

SAO 10-05-01

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

5- weld bushing as per dwg D3916

6- grind welds flush

PD 10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SAO 10/06/01

SAO 10/06/01

(6x)

PD 10.06.01

PKO

(x6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.05.31	100	Acceptable to use seamed mat'l				CP 10.05.31 QSI 042	S 10/06/01	

Part No: D 3916-041 PAR #: _____ Fault Category: Large Def. NCR: Yes No DQA: _____ Date: 10/06/04
 Resolution: SCVAP Disposition: SCVAP QA: N/C Closed: X Date: 10/06/04

NCR: 5688 58688		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.05.31	100	Excessive buckling in bend. But development Development for mat. Re: Process.	CP 10.05.31 QSI 042	Bend parts with seam on outside or side of bend. Scrap 2 Parts	SAR 10.06-07	S 10/06/04	CP 10.05.31 QSI 042	S 10/06/04

NOTE: Date & initial all entries

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Page 2

Item ID: D3916-041

Accept

Revision ID:

Item Name: Rib Assembly

Start Date: 5/17/2010 Start Qty: 6.00

Required Date: 5/21/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S 10/06/01

(X6)

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

S 10/06/01 (Gx)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/02

MK
10-6-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, May 17, 2010 8:25:54 AM

Page 1

Work Order ID: 58688

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC


IPP Rev:B as

Start Date: 5/17/2010

Required Date: 5/21/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	36.0000	7			
												
Bushing												

B58581 15 M10/05/26

Location	Loc Qty	Loc Code
WA	36	
54072	9	
58159	1	
58256	26	

M304TS0.750W.049

Purchased

No

100

f

417.9883

4.166



304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT	274.0389789	
113763	0	
114323	72.3689789	
114677	201.67	
MAT017	143.9493368	
113763	24.25	
114298	119.699337	

SAD 10-05-26

4.166 X6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

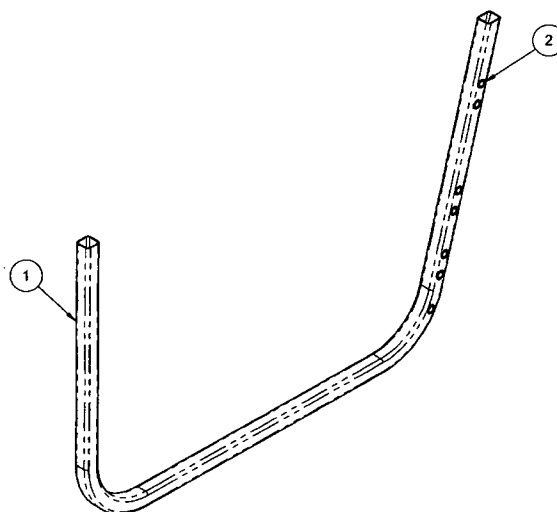
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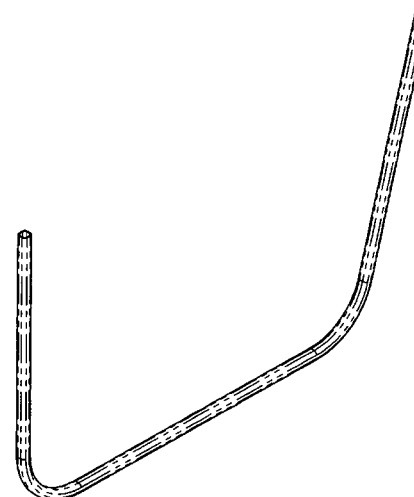
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58688

BS10-5-17







D3916-041 RIB ASSY



D3916-5 LIGHT RIB

RELEASED
2010-03-12
MP

A	NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3916	SHEET 1 OF 4
APPROVED			TITLE	SCALE
DE APPR.			RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

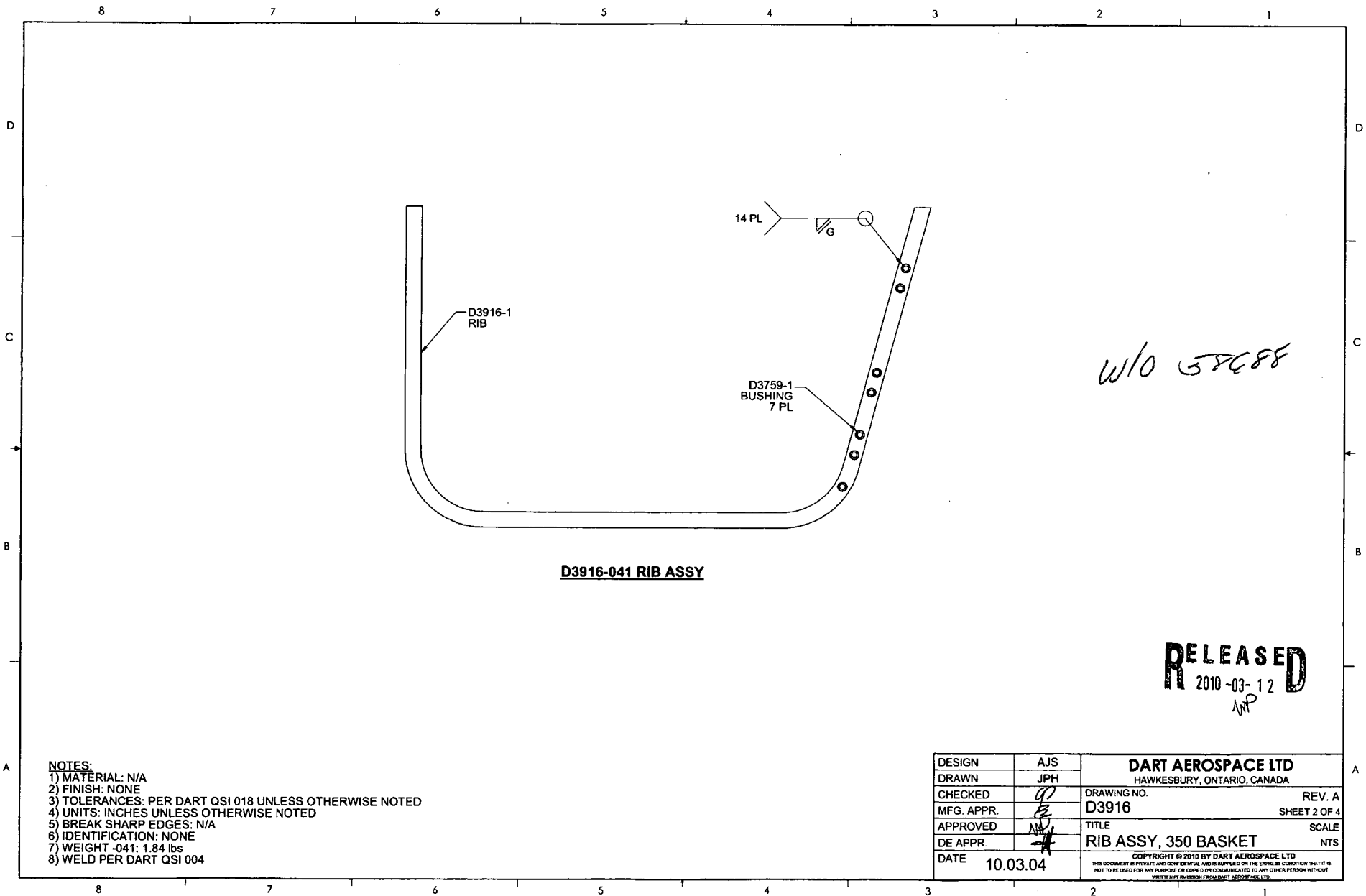
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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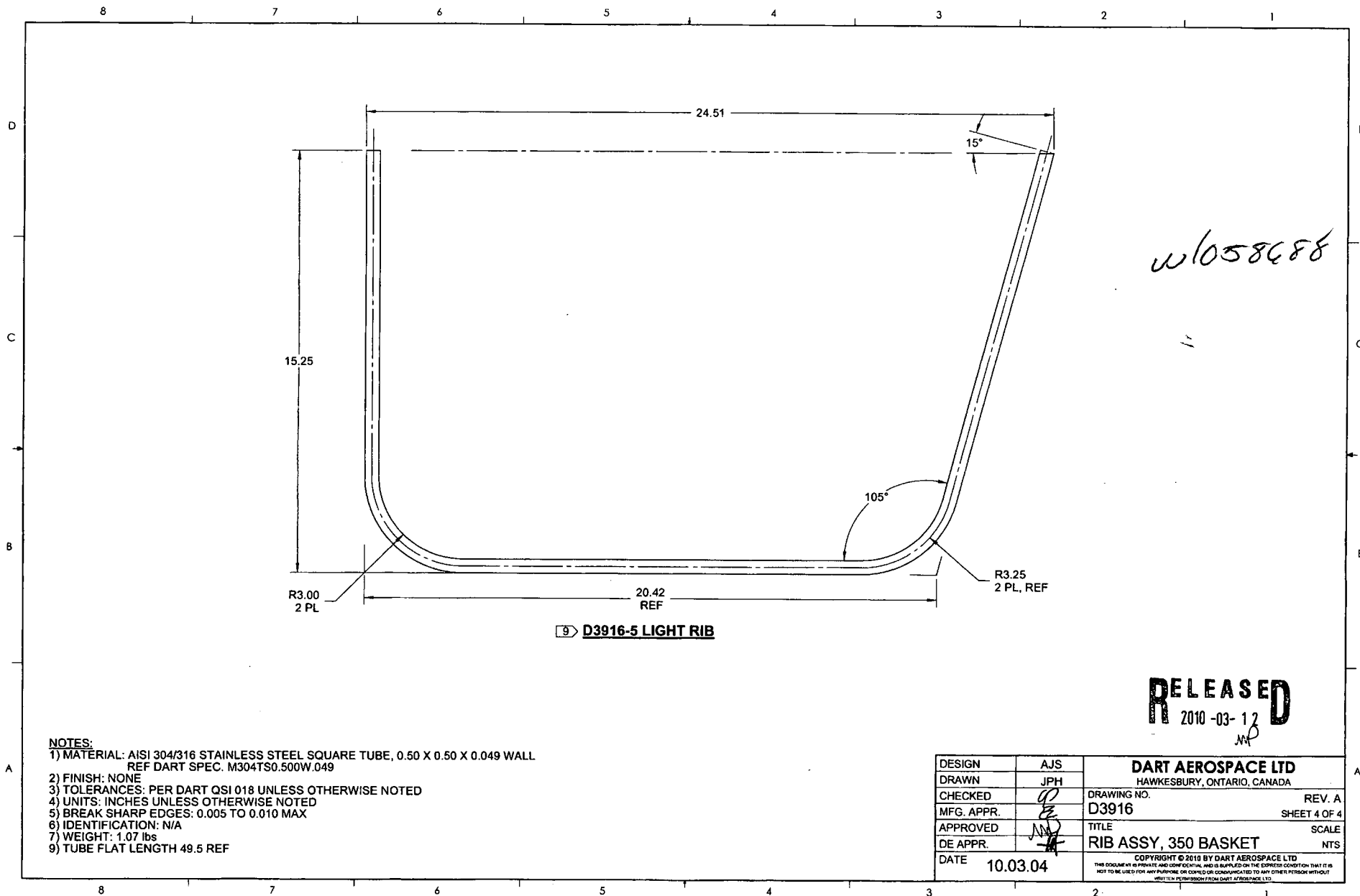
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9) **D3916-5 LIGHT RIB**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12
JMB

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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